

Date: Wednesday, 23/04/2008 10:22:23 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number	: 38769		
Estimate Number	: 10824		
P.O. Number	:	Part Number	: D412630032
This Issue	: 23/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN D412-630
First Issue	: / /	Project Number	: N/A
Previous Run	: 35820	Drawing Revision	: L
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 30/04/2008
Checked & Approved By	:	Qty:	2 Um: Each
Comment	: EST. REV. A 05.11.21 NEW ISSUE EC EST. REV. B 05.12.19 updated pick list EC EST. REV. C 07.11.12 ecn 1019, nochg EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-034 CHG001

-032

S 08/08/13

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

ED 08/07/08 (2)

MF 08.08.13

3.0	D3463042	Step Weldment Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	B35862

B35862

B 8/4/20

4.0	D3443043	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	37089

37089

8/4/23

(2)

56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 23/04/2008 10:22:23 AM
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Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D3443041 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
1 D3443-041 Strut ass'y

Batch

New Batch
B38821x2

18-08-04/14 (K2)

6.0 D34439 Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 D3443-9 Pin

Batch

30258

SP

7.0 AN4CH3 SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 AN4CH3 BOLT
A/R MS20995c41e Lockwire

Batch

103248
m/61537

mf 08-08-13 SP

8.0 AN4C14 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
1 AN4C14 BOLT

Batch

103248

SP

9.0 D34547 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 D3454-7 Bushing

Batch

35636

8/4/23

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN3104

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-4	Nut	105080 (3Y)

107139 (1x)

SP

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	106043

SP

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	28171

SP

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	33700

SP

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	103786

8/4/23

SP

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS24665302

Cotter Pin



2x

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	M106763

SP

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

50808/13 42

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3454-1	Bushing	33730

SP

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-3	Bushing	35171

SP

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-5	Bushing	34842

8/4/24

SP

Date: Wednesday, 23/04/2008 10:22:23 AM
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Process Sheet

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

6

D3455-1

Spacer

30226

2

50

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3455-3

Spacer

1328172

50

23.0

D3462042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3462-042

Bracket ass'y

35860

SP

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN310-4

Nut

107139

30

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

AN310-5

Nut

105250

8/4/24

50

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Process Sheet

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	106 574

SP

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN44-C12	Eyebolt	140711 M107923 7/4/17

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C15	BOLT	103242

SP

29.0

AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C11	BOLT	103248

SP

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C15	BOLT	10121

8/4/24

SP

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Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	AN960C10	WASHER
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Comment: Qty.: 7.0000 EACH(s)/Unit Total : 14.0000 EACH(s)

Pick:

Qty	Part Number	Description	Batch
7	AN960C10	Washer	106302

SP

32.0	AN960C516	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C516	Washer	102840

SP

33.0	MS210433	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	MS21043-3	Nut	107288

SP

34.0	MS24665227	COTTER PIN
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-227	COTTER PIN	106093

SP

35.0	MS24665229	COTTER PIN
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-229	COTTER PIN	MA096

8/4/23

SP

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Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

NAS1515H5

Washer

~~4100133~~

8/4/13

~~4100133~~ * 50

M100433

M106041X

2x

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/08/13

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev:

B 32

8/8/13

50

2

39.0

QC21

FINAL INSPECTION/W/O RELEASE



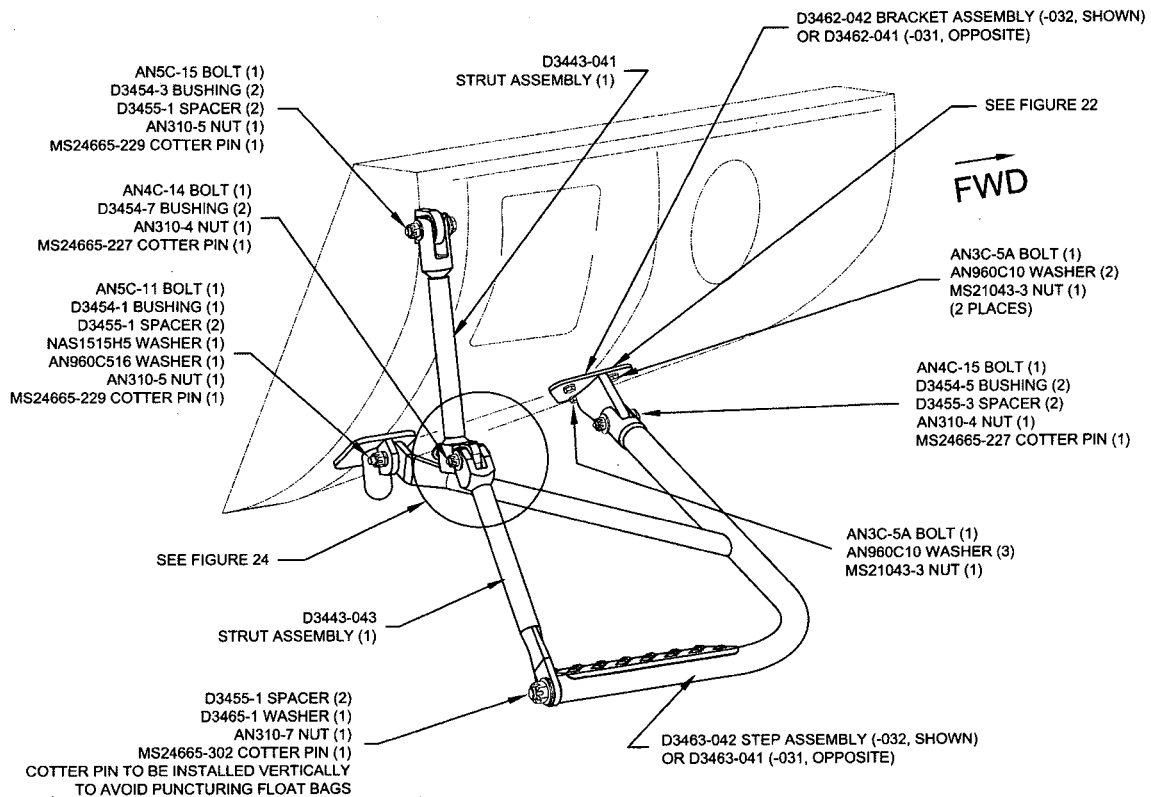
Comment: FINAL INSPECTION/W/O RELEASE

2008/08/14

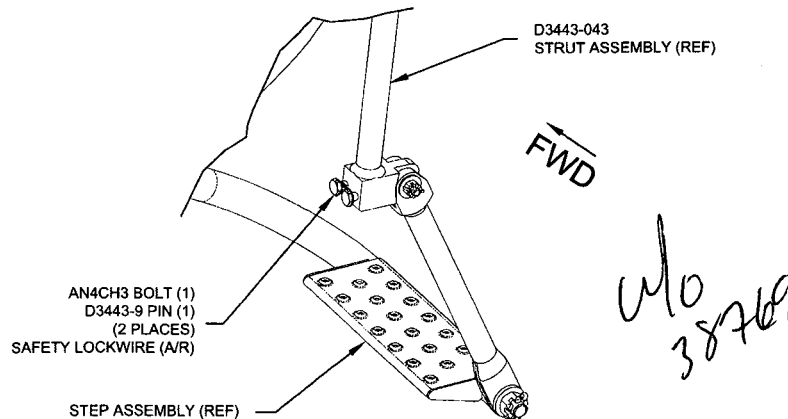
Job Completion



u 08.08.14



**FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



**FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**

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Revision: L
Date: 07.09.30

Date: Wednesday, 28/05/2008 10:11:29 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number : 38769	
Estimate Number : 10824	
P.O. Number :	Part Number : D412630032
This Issue : 28/05/2008 S.O. No. :	Drawing Number : IIN D412-630
Prsht Rev. : NC	Project Number : N/A
First Issue : 23/04/2008 Type : SMALL /MED FAB	Drawing Revision : L
Previous Run : 35820	Material :
Written By :	Due Date : 30/04/2008 Qty: 2 Um: Each
Checked & Approved By :	
Comment : EST. REV. A 05.11.21 NEW ISSUE EC	
EST. REV. B 05.12.19 updated pick list EC	
EST. REV.C 07.11.12 ecn 1019, nochg EC	
verifiedby:DD	

Additional Product

REFERENCE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

JW08-5-28

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

3.0	D3463042	Step Weldment Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	

4.0	D3443043	Strut Weldment Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	